

Date: Monday, 2/19/2007 8:07:58 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 30756		
Estimate Number	: 12714		
P.O. Number	: <i>N/A</i>	Part Number	: D353639
This Issue	: 2/19/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3536 <i>Rev A</i> <i>PH</i> <i>07.02.19</i>
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	:	Drawing Revision	: U/R
		Material	: <i>N/A</i>
Written By	:	Due Date	: 2/26/2007
Checked & Approved By	: <i>07.02.19</i>	Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
-----	------------	----------------------



Comment: Qty.: 0.7911 sf(s)/Unit Total : 9.4928 sf(s)  
 NEOPRENE SHEET 0.063  
 Batch: *M 103104*

*SAD 07/03/10*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3536  
 Dwg Rev: *A*  
 Prog Rev: *A*

2-Deburr if necessary

*SAD 07/03/10*

*(12)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/03/10*

*(12)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*07/03/12 (12)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

*07/03/13 (12) CR*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PA Date: 07/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 30756

Part Number: D353639

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

FD 07/03/14

Job Completion



U 07.03.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

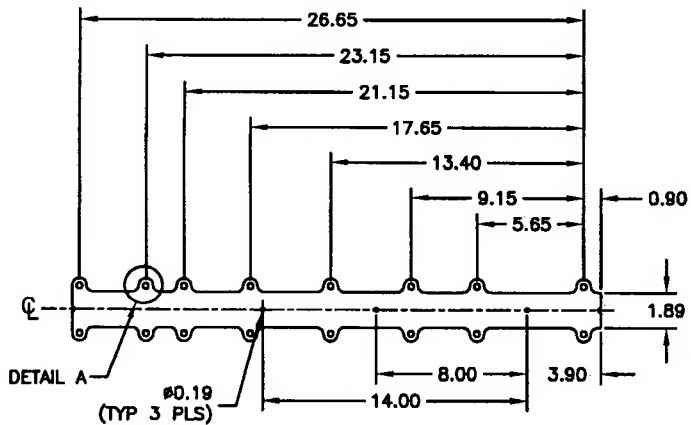
**NOTE:** Date & initial all entries

**DART**

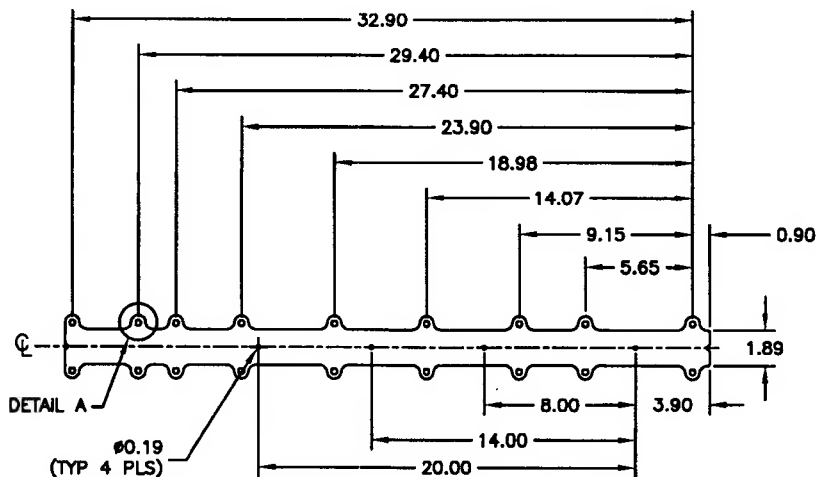
RELEASED

09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE
				1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

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WITHOUT NOTICE  
WORK ORDER  
NO. 30756

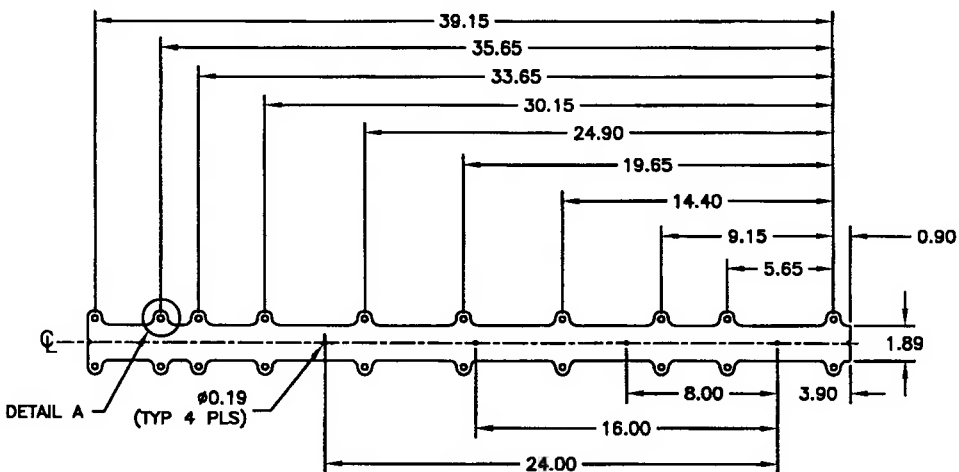
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

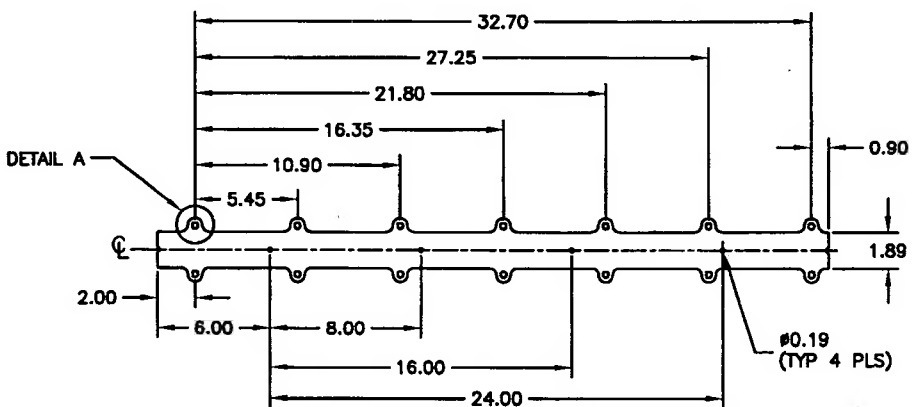
**DART**

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 2 OF 6
DATE	06.10.25	TITLE	GASKET	SCALE	1:10

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07.02.12



**D3536-15 GASKET**




**D3536-21 GASKET**

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NO. 30754

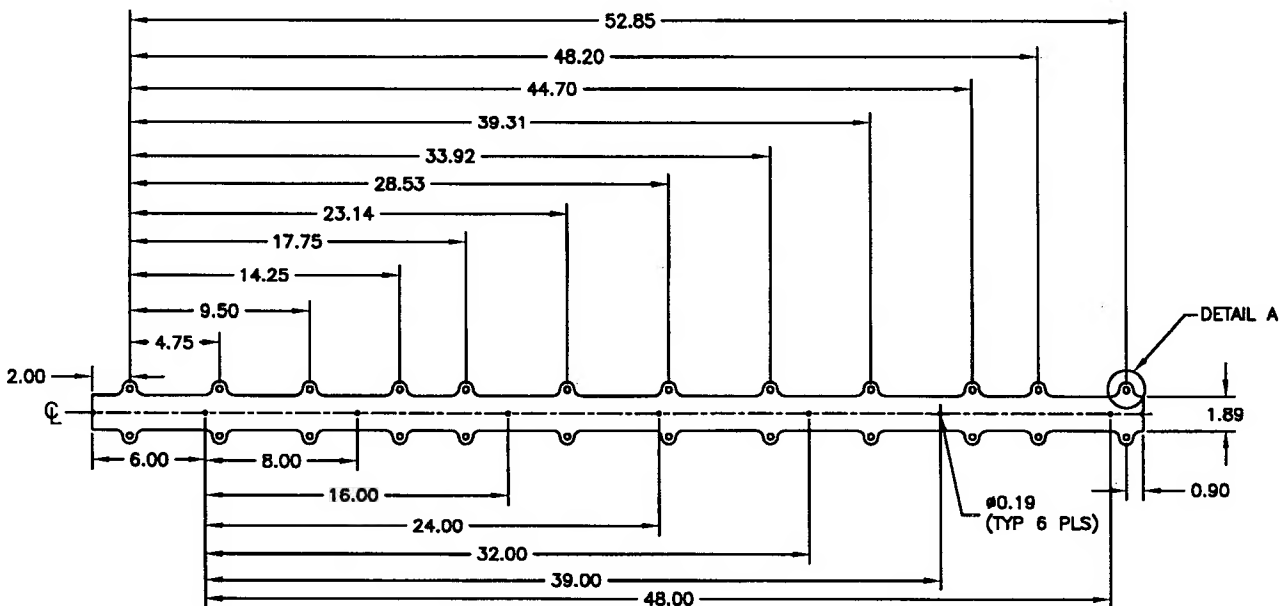
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

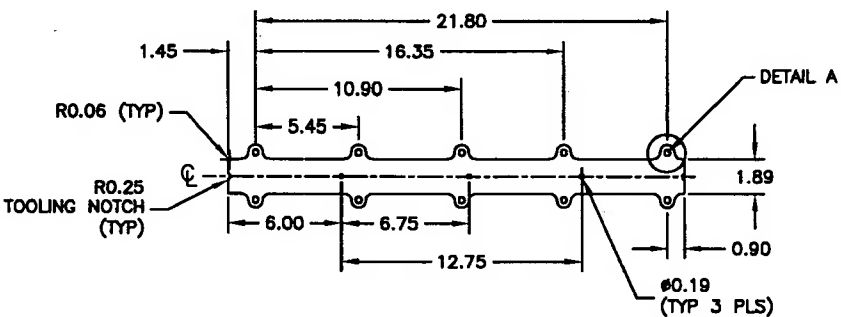
# DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. A SHEET 3 OF 6		
CHECKED	PH	APPROVED				DRAWING NO.	D3536
DATE	06.10.25	TITLE	GASKET			SCALE	1:10

07.02.12



**D3536-23 GASKET**



**D3536-25 GASKET**

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WORK ORDER  
NO. 30756

## NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60  
DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT  
PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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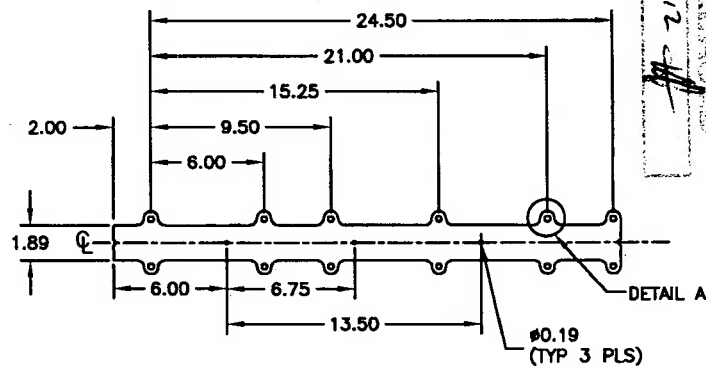
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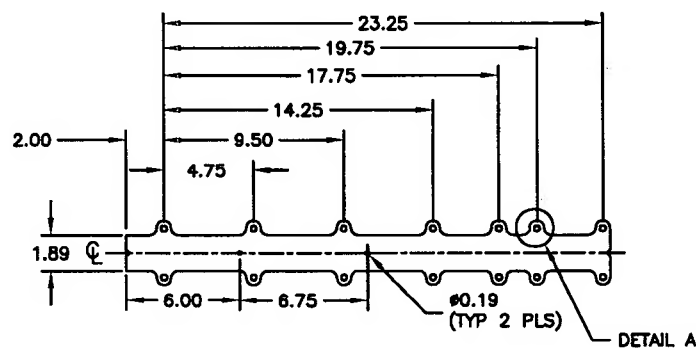
# DART

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 4 OF 6	
		SCALE <b>1:10</b>	

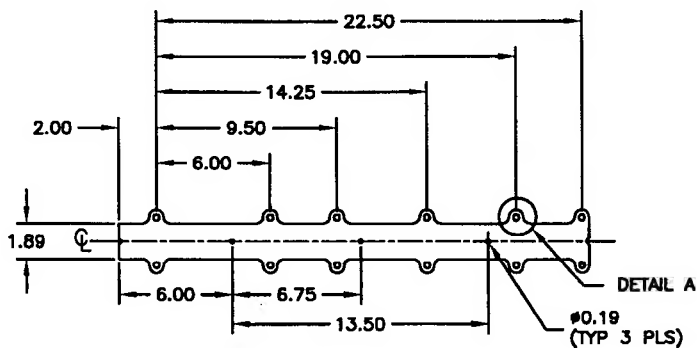
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

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WORK ORDER  
NO. **30750**

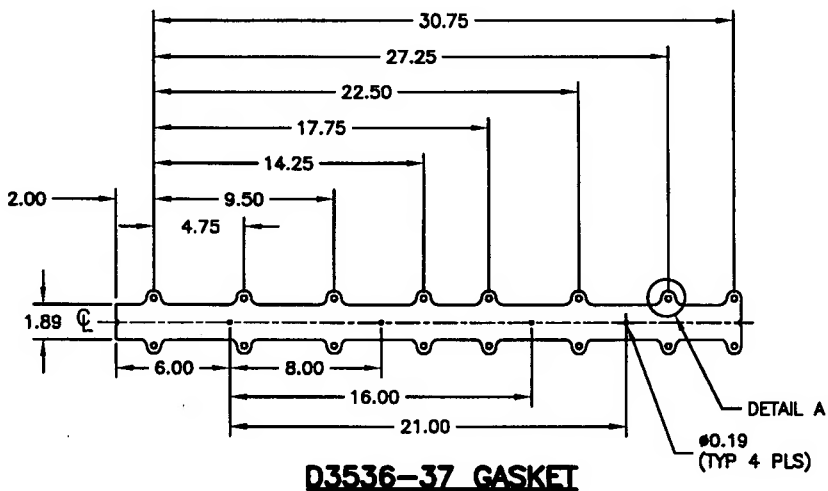
- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION



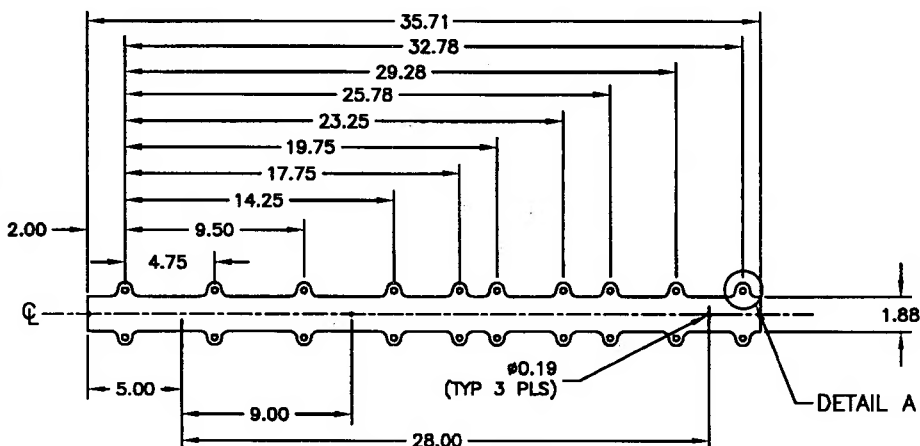
**DART**

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	06.10.25	TITLE	D3536	GASKET	SHEET 5 OF 6
					SCALE 1:10

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**D3536-37 GASKET**



**D3536-39 GASKET**

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WORK ORDER  
NO. 20756

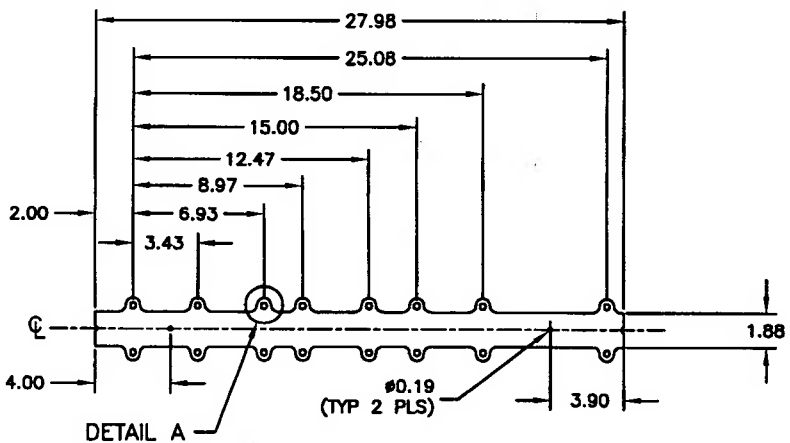
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 6 OF 6	SCALE <b>1:10</b>

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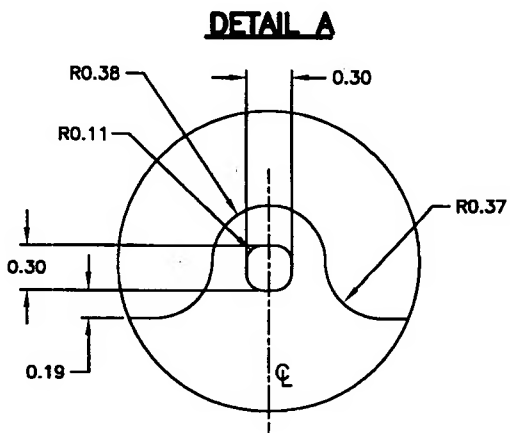


### D3536-41 GASKET

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WITHOUT NOTICE  
WORK ORDER  
NO. **30754**

#### NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30756
<b>Description:</b> Gasket		<b>Part Number:</b> D3536-39
<b>Inspection Dwg:</b> A	<b>Rev:</b> A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/- 0.030	35.71	/		M-T	
32.78	+/- 0.030	32.75	/		M-T	
29.28	+/- 0.030	29.25	/		M-T	
25.78	+/- 0.030	25.75	/		M-T	
23.25	+/- 0.030	23.25	/		M-T	
19.75	+/- 0.030	19.75	/		M-T	
17.75	+/- 0.030	17.75	/		MT	
14.25	+/- 0.030	14.25	/		M-T	
9.50	+/- 0.030	9.480	-		Vern	
4.75	+/- 0.030	4.729	-		Vern	
1.88	+/- 0.030	1.89	-		Vern	
Ø0.19	+/- 0.030	Ø0.20	✓		Vern	
0.300	+/- 0.030	0.30	✓		Vern	
0.300	+/- 0.030	0.30	✓		Vern	
0.063	+/- 0.010	0.060	✓		Vern	

<b>Measured by:</b> EAM	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>
<b>Date:</b> 07/03/10	<b>Date:</b> 07/03/12	<b>Date:</b>
<b>Rev</b>	<b>Date</b>	<b>Change</b>
A		New Issue
		<b>Revised by</b> KJ/JLM
		<b>Approved</b>